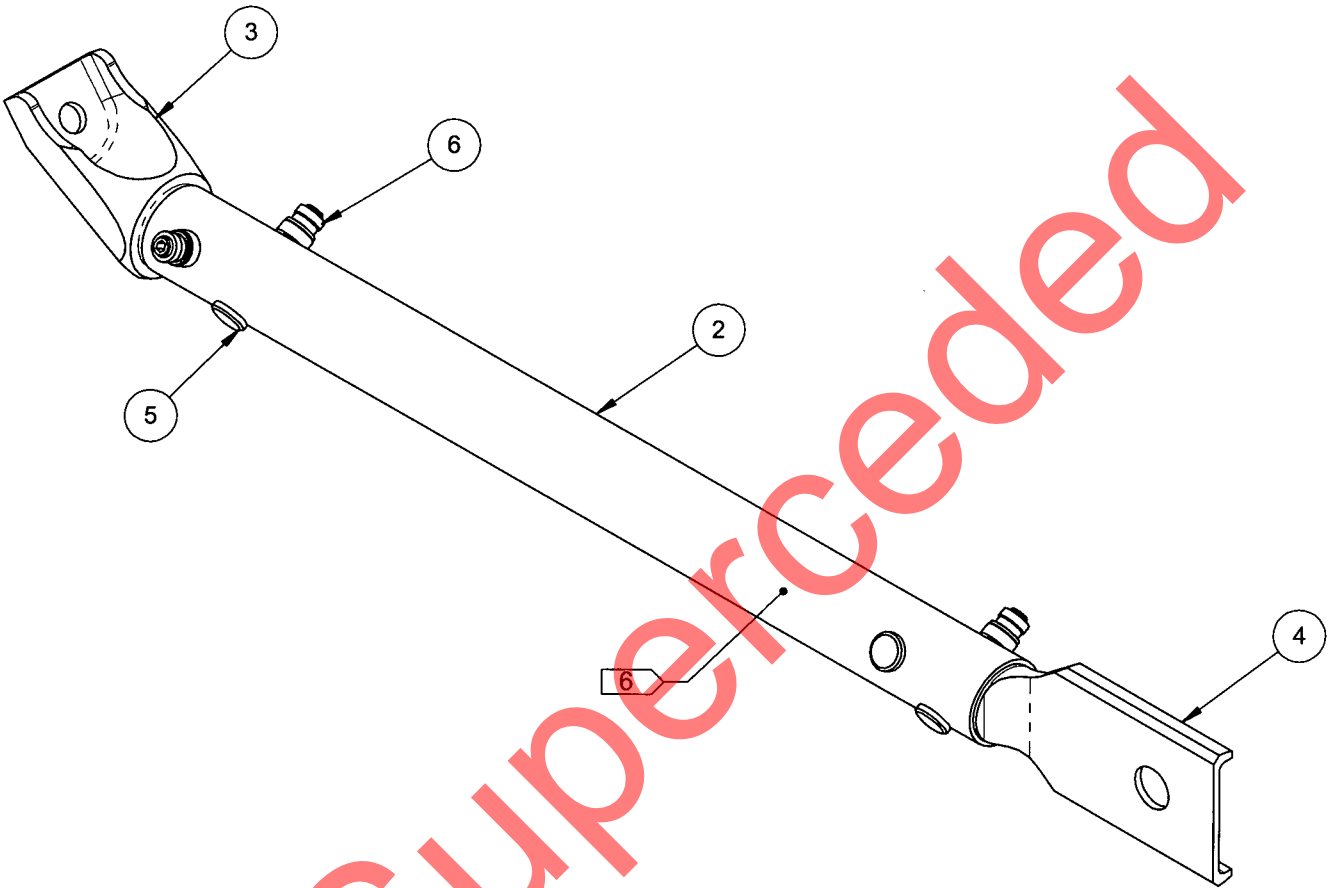


ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4878-041	FWD LEG ASSEMBLY, LH
2	1	D4878-1	STRUT
3	1	D4883-1	END FITTING
4	1	D4884-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

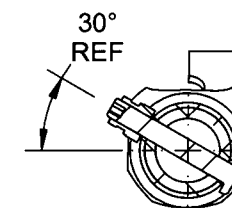
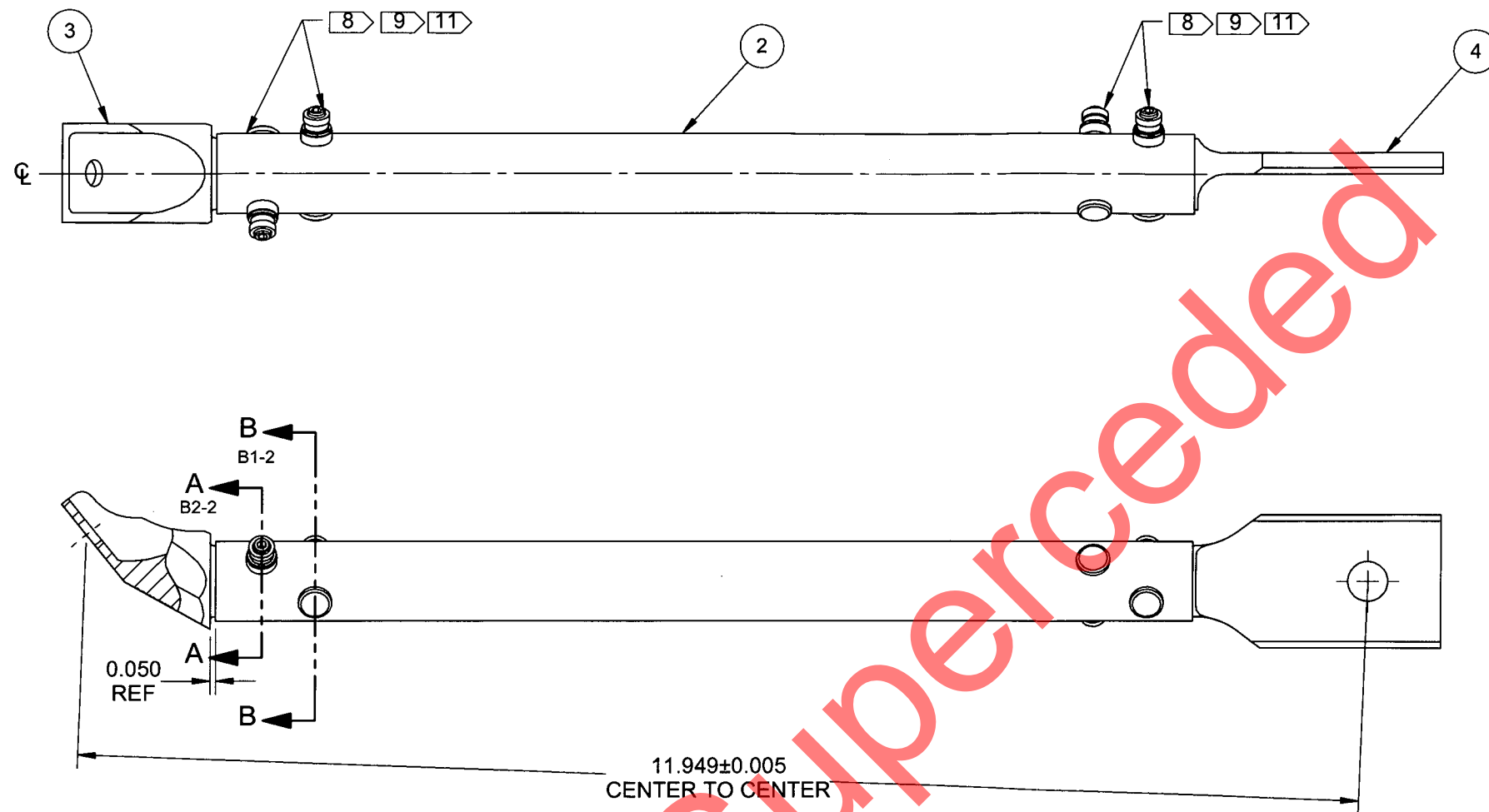


**D4878-041 FWD LEG ASSEMBLY, LH**

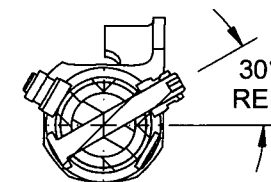
- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 0.65 lbs  
8) ALIGN PILOT HOLES IN D4878-1 WITH PILOT HOLES IN D4883-1 & D4884-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9966  
9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET  
10) ASSEMBLE PER DART TOOL DT9966  
11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	<b>D4878</b>	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
DATE	13.12.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION A-A** C7-2  
2 PL, SIMILAR



**SECTION B-B** C7-2  
2 PL

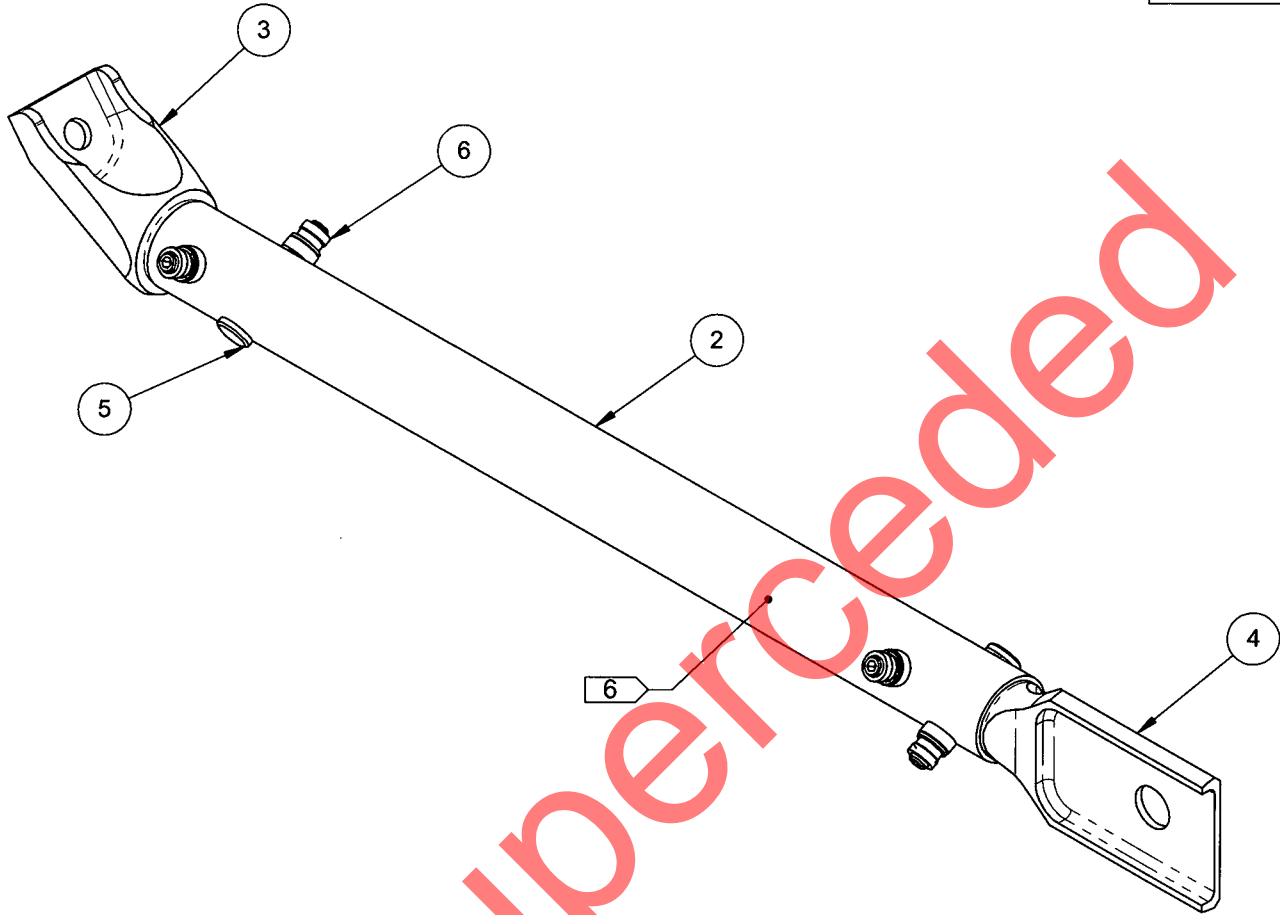
**D4878-041 FWD LEG ASSEMBLY, LH**  
AUXILIARY VIEW

RELEASED  
11-2013-02-12

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	<b>D4878</b>	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4878-042	FWD LEG ASSEMBLY, RH
2	1	D4878-1	STRUT
3	1	D4883-1	END FITTING
4	1	D4884-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



**D4878-042 FWD LEG ASSEMBLY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4878-1 WITH PILOT HOLES IN D4883-1 & D4884-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9967
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9967
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

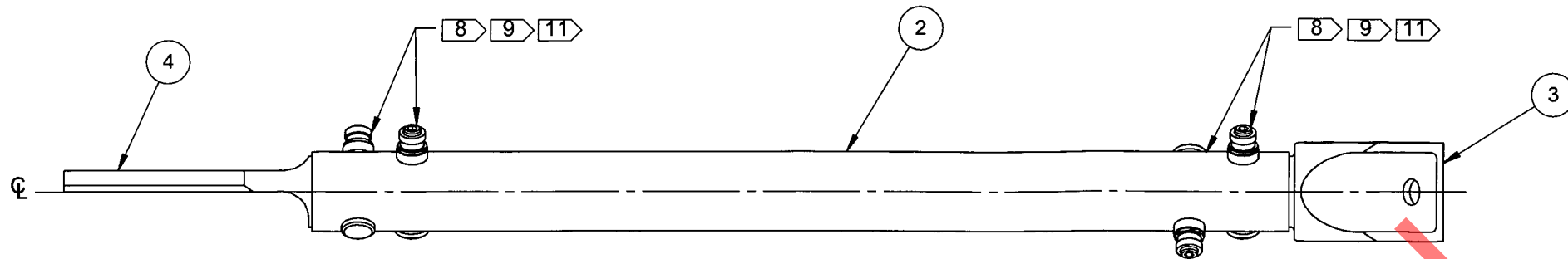
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	<b>D4878</b>	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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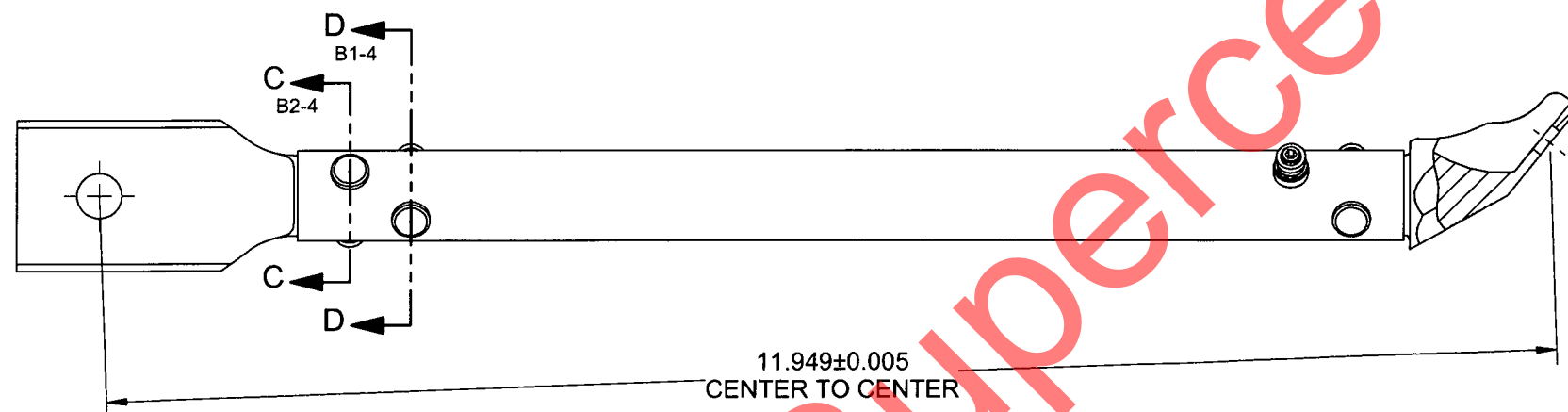
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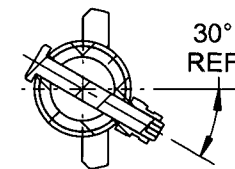
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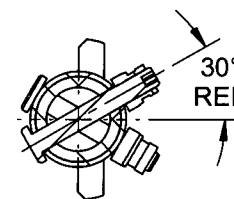


B

B



**SECTION C-C** C7-4  
2 PL, SIMILAR



**SECTION D-D** C7-4  
2 PL

**D4878-042 FWD LEG ASSEMBLY, RH**  
AUXILIARY VIEW

RELEASED  
2013-12-12

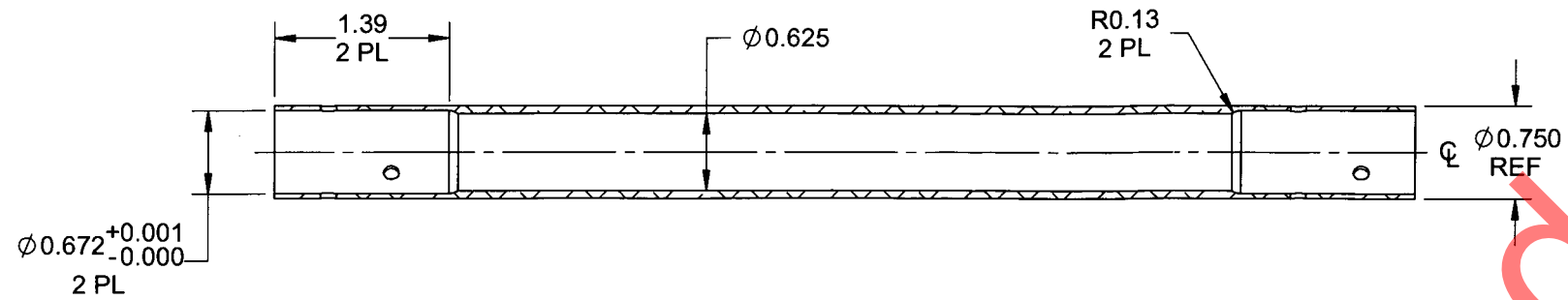
A

A

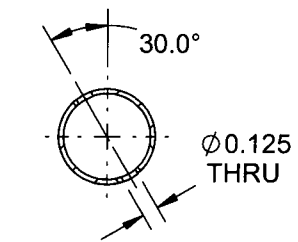
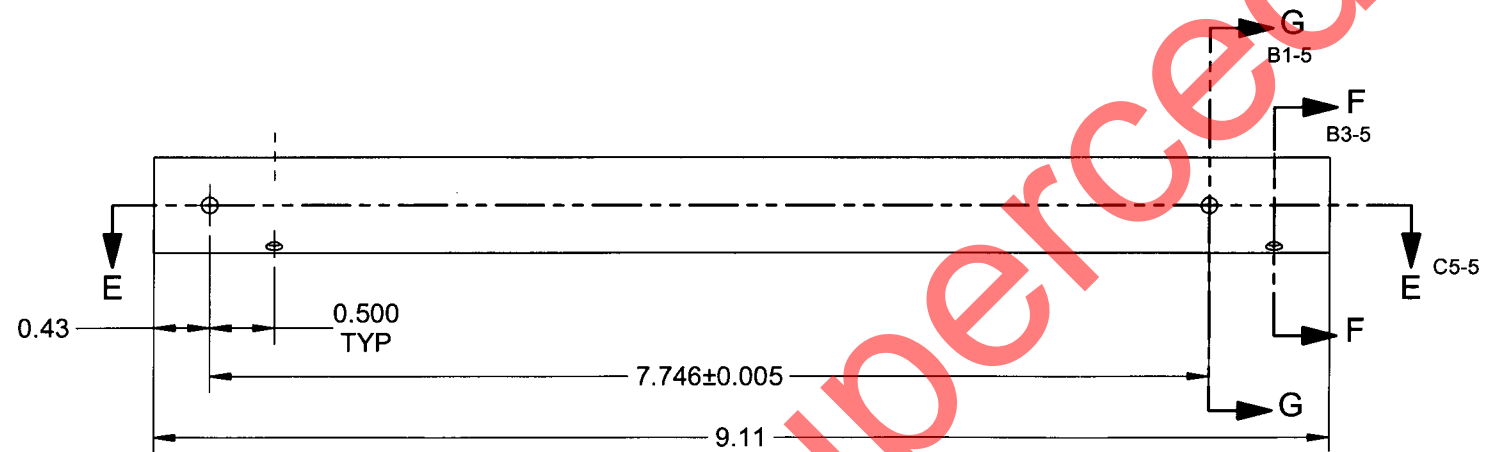
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4878</b>	REV. A
MFG. APPR.	JLM	SHEET 4 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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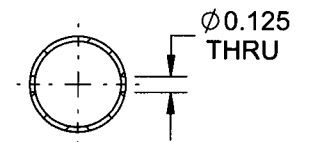
8 7 6 5 4 3 2 1



**SECTION E-E** C4-5



**SECTION F-F** C4-5  
2 PL



**SECTION G-G** C4-5  
2 PL

**D4878-1 STRUT**

- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.31 lbs
  - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4878</b>	REV. A
MFG. APPR.	JLM		SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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